

Date: Thursday, 20/11/2008 3:35:25 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: INSIDE WASHER		
Job Number	: 43625			Part Number	: D32331		
Estimate Number	: 11152			Drawing Number	: D3233 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 20/11/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 21/12/2008		
Previous Run	: 43447			Qty:	20	Um:	Each
Written By	:						
Checked & Approved By	: <u>JLJ 08.11.21</u>						
Comment	: Est. B 05.03.31 Added Powder Coat KJ/JLM						
Additional Product							
Job Number:							
Seq. #:	Machine Or Operation:	Description :					
1.0	M1020TR2000W500	1020-1025 round tubing 2.00 x .500w					
							
Comment: Qty.: 0.0656 f(s)/Unit Total : 1.3125 f(s) 1020-1025 Round Tube Material: AISI 1020-1025 Seamless Tubing 2" x 0.500" wall (M1020TR2.000W.500) Identify for D3233-1 Batch: <u>M102210</u>							
2.0	HARDINGE	HARDINGE CNC LATHE SMALL					
							
Comment: HARDINGE CNC LATHE SMALL Turn as per Folio FA517 and Dwg D3233 Deburr							
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE					
							
Comment: INSPECT PARTS AS THEY COME OFF MACHINE							
4.0	QC8	SECOND CHECK					
							
Comment: SECOND CHECK							
5.0	POWDER COATING	POWDER COATING					
							
Comment: POWDER COATING Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3							
START TIME:	<u>3:30</u>			FINISH TIME:	<u>4:00</u>		
OVEN TEMPERATURE:	<u>320</u>				<u>01</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:35:25 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INSIDE WASHER

Job Number: 43625

Part Number: D32331

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-02 20X

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST490

XJ

08/12/02 X20

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 08-12-02

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43625
Description: Inside Washer	Part Number:	D3233-1
Inspection Dwg: D3233	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

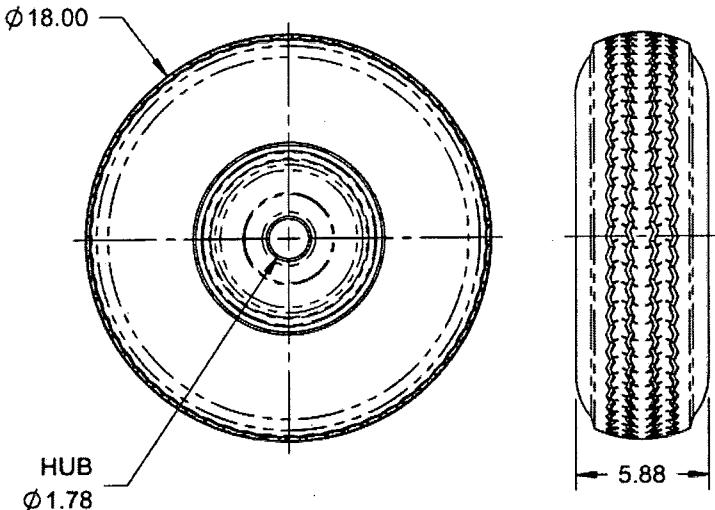
X First Article Prototype

Measured by:	<u>Ch</u>	Audited by:	<u>Onf</u>	Prototype Approval:	N/A
Date:	08/11/26	Date:	08/11/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	<i>[Signature]</i>

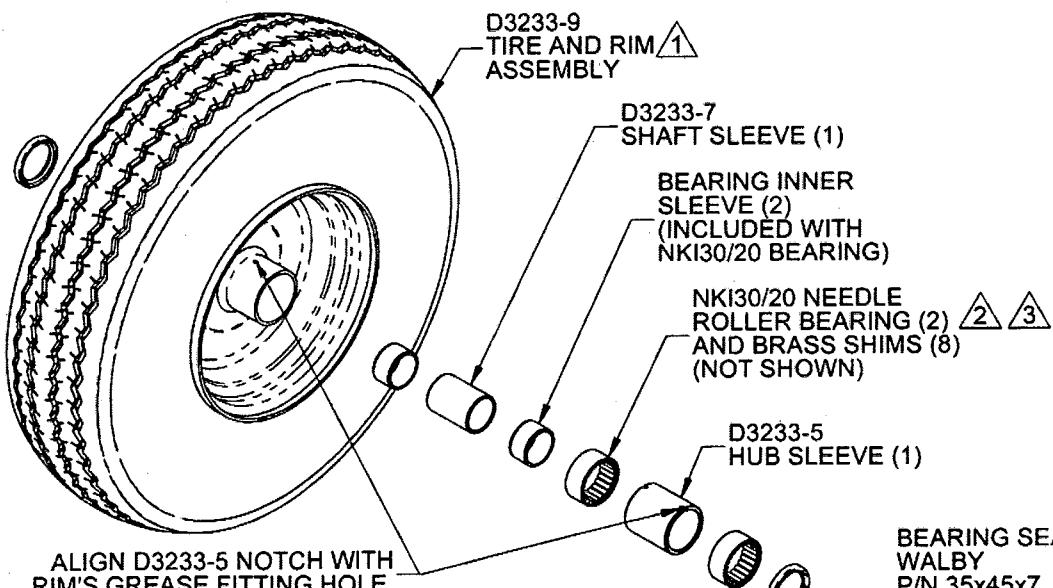
DART

DESIGN <i>b3</i>	DRAWN BY <i>DBP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PF</i>	APPROVED <i>DBP</i>	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	

**RELEASED**
DBP
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMMENDATIONS
ARE 75 PSI FOR HIGH SPEED USE.



D3233-041 WHEEL ASSEMBLY

NOTES:

1) POSSIBLE SUPPLIER: McMaster-Carr, P/N 8353T74

2) POSSIBLE SUPPLIER: GENERAL BEARING

3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT WITHOUT NOTICE

4) POSSIBLE SUPPLIER: GENERAL BEARING

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

BEARING SEAL

WALBY

P/N 35x45x7

△

OR

CR 35x45x7 HMS4 R

P/N 13927

R

(2 PLACES) SHOP COPY

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WORK ORDER

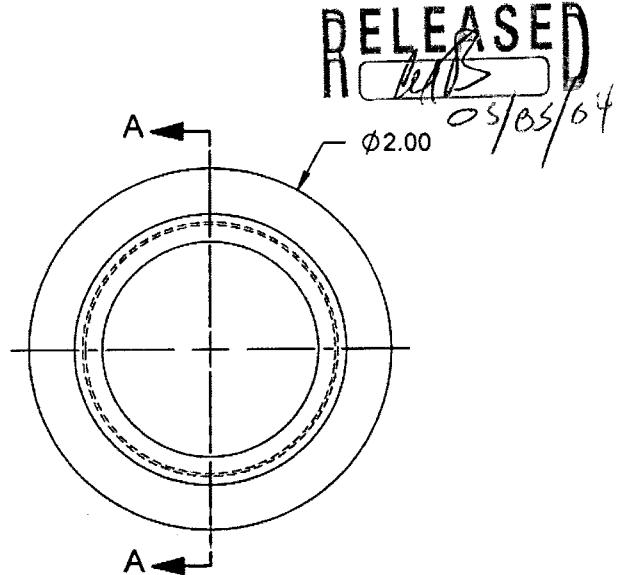
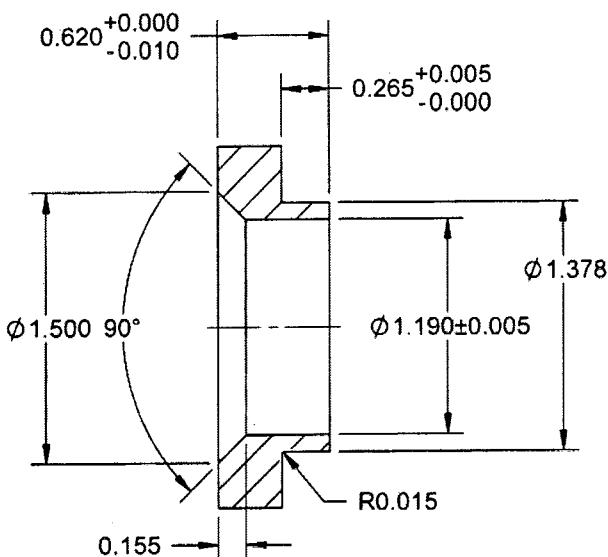
NO. 436025

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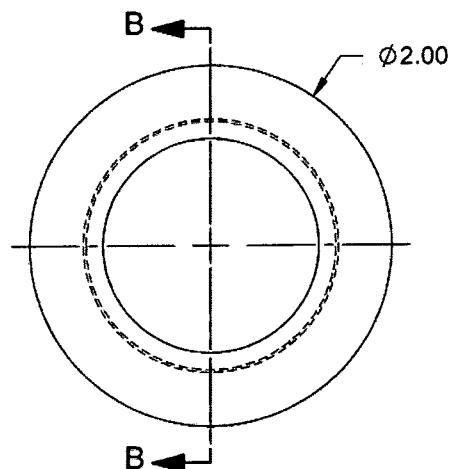
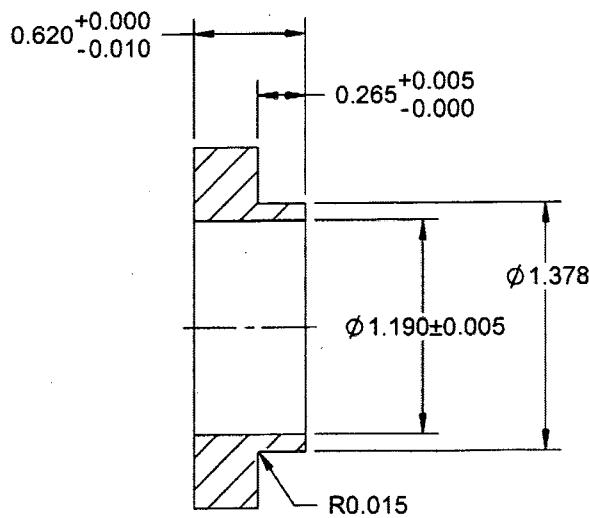


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1	



SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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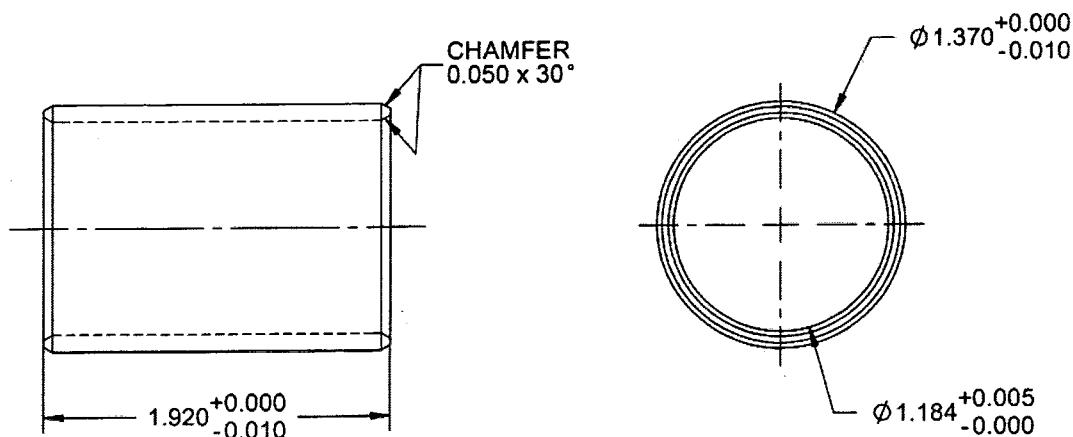
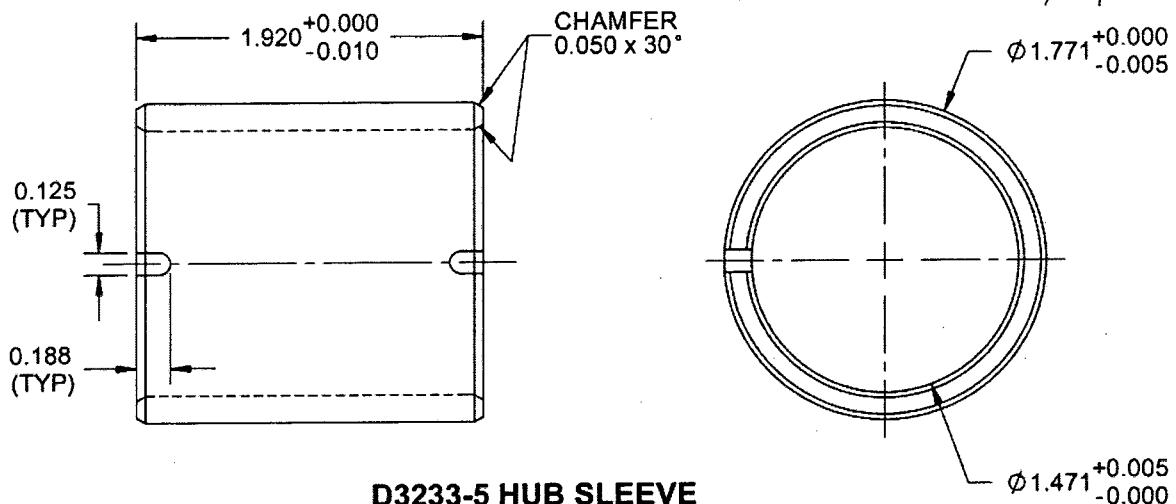
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE	05.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1

RELEASED
R [initials]
05/05/04**D3233-7 SHAFT SLEEVE****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, ~~SEAMLESS~~ STROLLED COPY
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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